

Work Order ID 73316

Wednesday, August 31, 2011 10:50:07 AM

Page 1

Item ID: D3535-39

Accept

Revision ID:

Item Name: Wearshoe

Setup Start

Stop

Start Date: 9/1/2011 Start Qty: 20.00

Required Date: 9/15/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *11-09-01*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 f Dwg Rev: *B* Prog Rev: *B* 2-
Deburr if necessary

304.040

B11-9-15

(20)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-9-15

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Sublot 1

counts
(x20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73316
Description: Wearshoe		Part Number: D3535-39
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	✓		T B01	
32.775	+/-0.010	32.775	✓		T	
29.275	+/-0.010	29.275	✓		T	
25.775	+/-0.010	25.775	✓		T	
23.250	+/-0.010	23.250	✓		T	
19.750	+/-0.010	19.750	✓		T	
17.750	+/-0.010	17.750	✓		T	
14.250	+/-0.010	14.250	✓		T	
9.500	+/-0.010	9.500	✓		T	
4.750	+/-0.010	4.750	✓		T	
2.000	+/-0.010	2.000	✓		T	
5.00	+/-0.030	5.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
28.00	+/-0.030	28.00	✓		T	
Ø0.188	+0.005/-0.001	0.182	✓		V B02	
1.885	+/-0.010	1.888	✓		V	
0.300	+/-0.010	0.309	✓		V	
0.300	+/-0.010	0.306	✓		V	
0.038	+/-0.010	0.038	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-9-15	Date: 11/9/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	B

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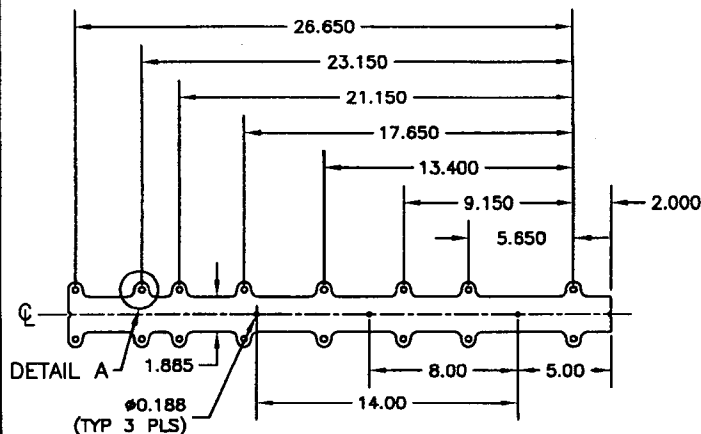
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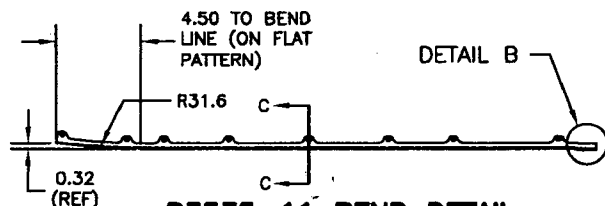
DART

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07.04.24

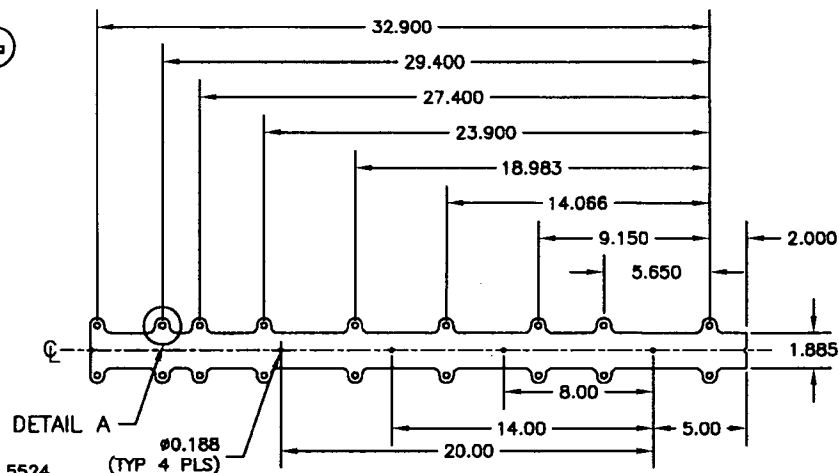


D3535-11F FLAT PATTERN

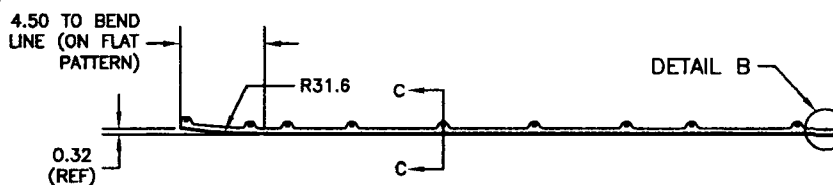


D3535-11 BEND DETAIL

21492 F



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 1 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

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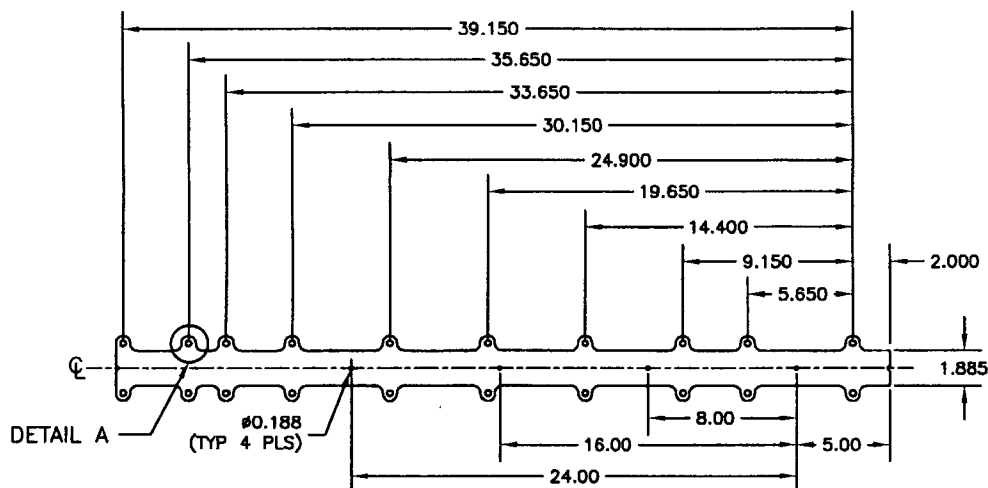
NOTE: Date & initial all entries

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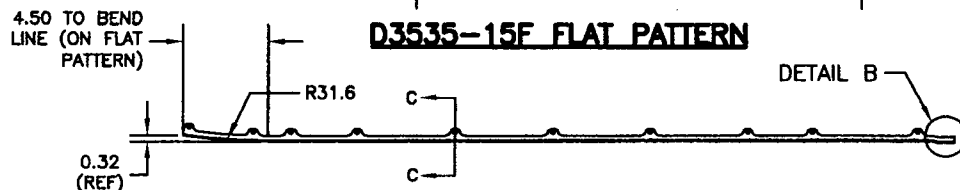
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		D3535	SHEET 2 OF 7	
DATE	TITLE	SCALE		
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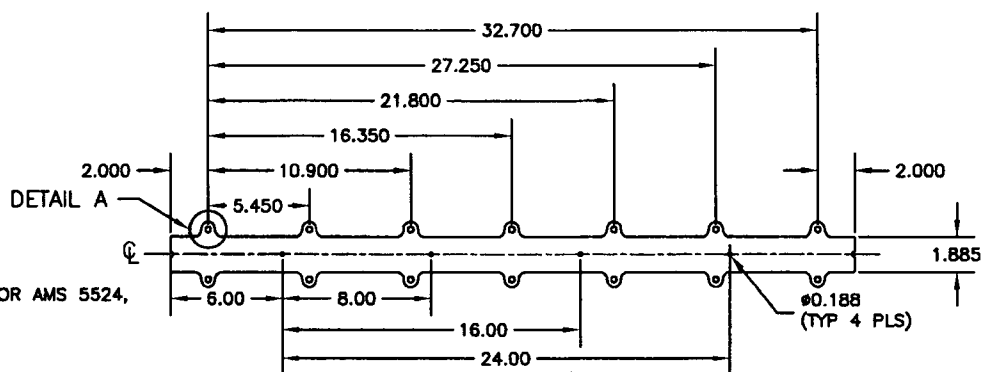


D3535-15F FLAT PATTERN

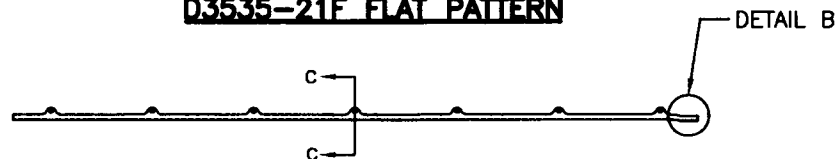


D3535-15 BEND DETAIL

01996 #



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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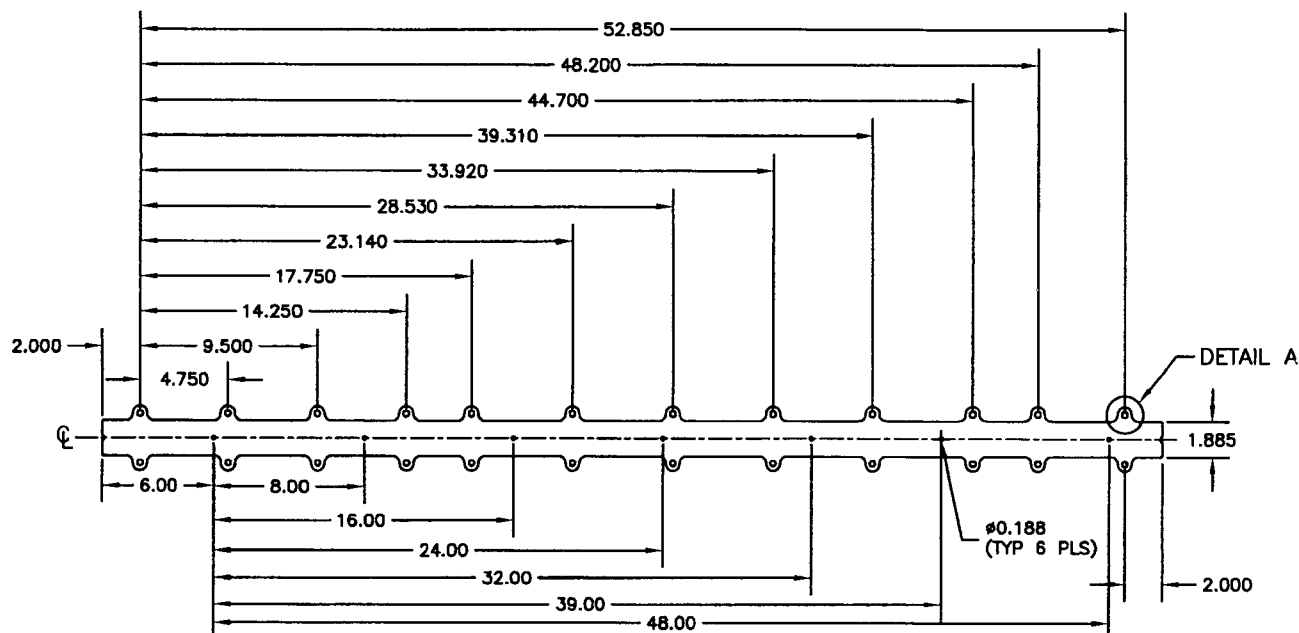
NOTE: Date & initial all entries

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#	#	D3535	SHEET 3 OF 7
DATE	TITLE	WEARSHOE	SCALE
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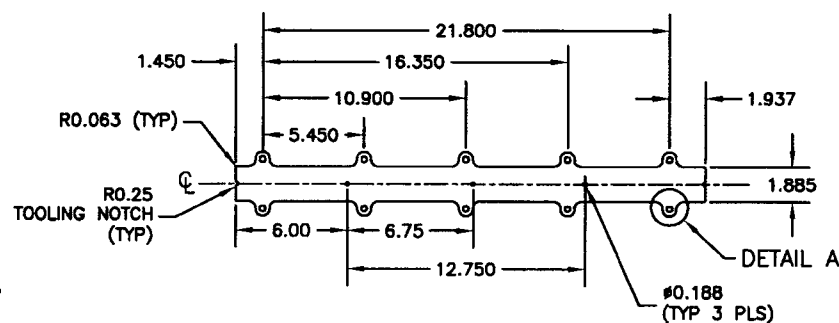


D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL

9144L #



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

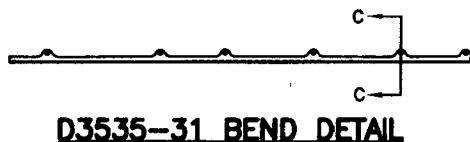
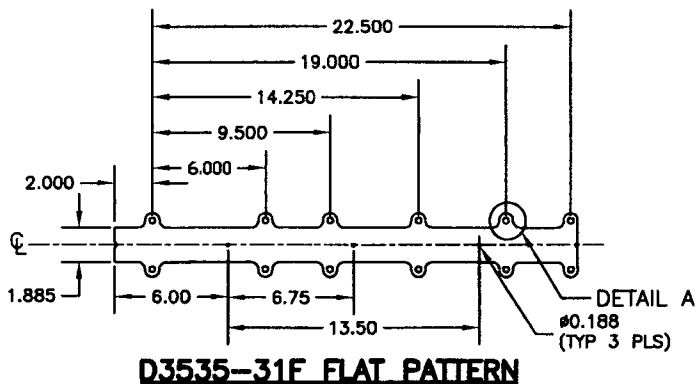
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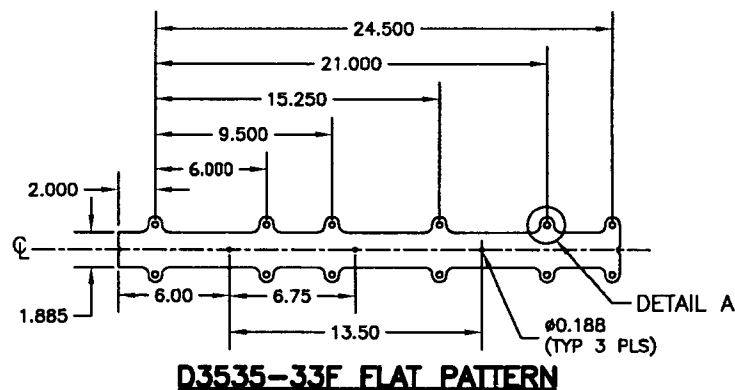
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#73316



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		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

W/O:		WORK ORDER CHANGES					
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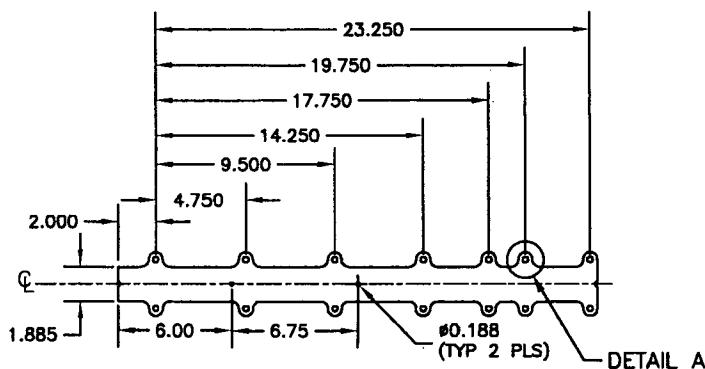
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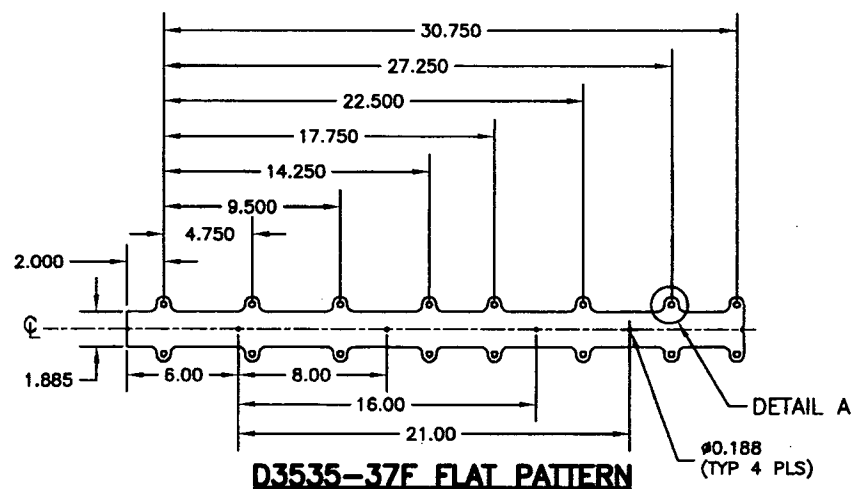


D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL

#73316



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REV. B
			WEARSHOE	SHEET 5 OF 7
				SCALE 1:10

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

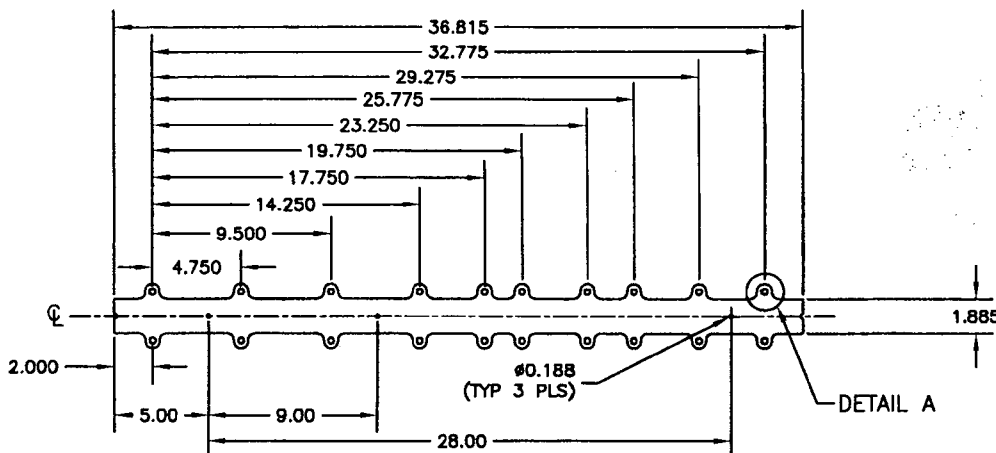
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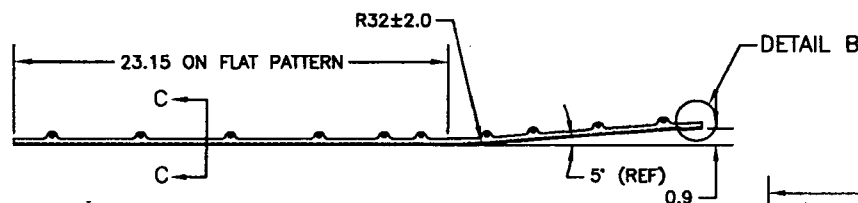
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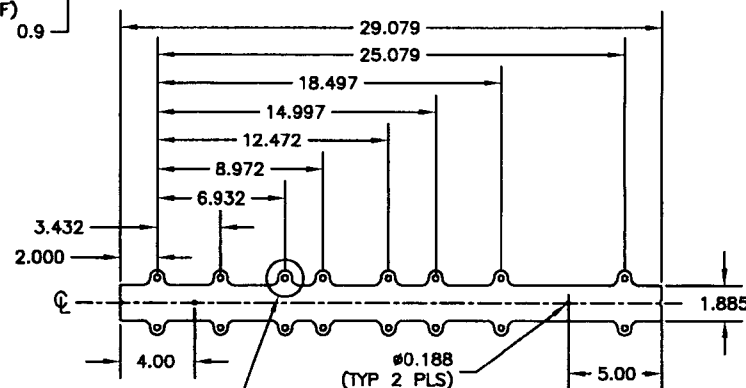
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
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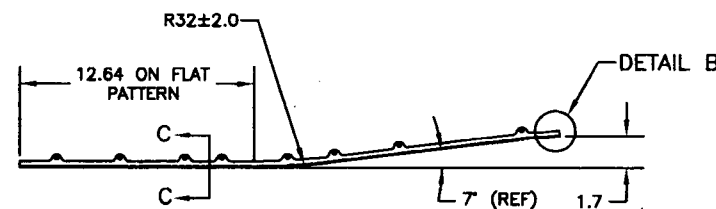
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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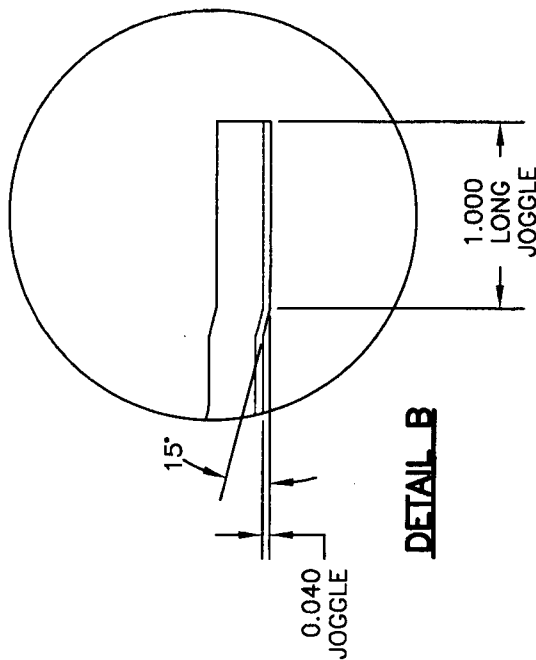
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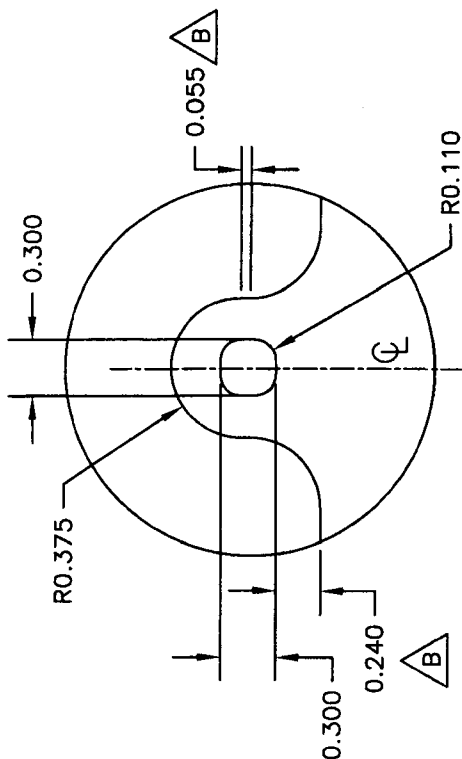


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

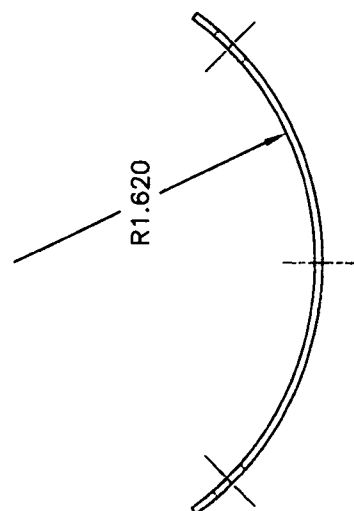
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DETAIL B



DETAIL A



SECTION C-C

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